

Date: Monday, 05/01/2009 7:58:10 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CROSSBOLT SPACER
 Job Number : 44364
 Estimate Number : 11010
 P.O. Number :
 This Issue : 05/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 44323
 Part Number : D2649
 Drawing Number : D2649 REV B1
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 31/01/2009 Qty: 200 Um: Each
 Written By :
 Checked & Approved By : JUD 08-01-05
 Comment : Est F 02.03.26 Added turning on Cobra NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0375W058

6061-T6 RD Tube .375 x.058W



Comment: Qty.: 0.2975 f(s)/Unit Total: 59.4930 f(s)
 6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch M110271

09/01/07 200 pcs

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA214 on cobra machine.

09/01/07

200 pcs

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/01/07

200 pcs

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09/01/08

200

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: BARCLAY

09/01/09 (200)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/09

200

Job Completion



MF 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

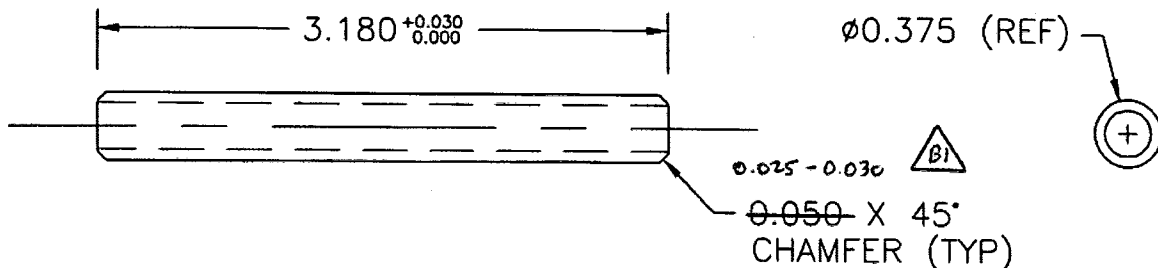
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER